

Work Order ID 51159

August 5, 2009 7:48:29 AM



Page 1

Item ID: D3041-1

Revision ID: C-1

Item Name: Clamp

Start Date: 8/05/09

Start Qty: 30.00

Required Date: 8/10/09

Req'd Qty: 30.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3041

Rev C

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut D2423 Extrusion: 1.250" Long

0.00

0.00

DTT 09/08/05

30 0

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine per folio FA153

0.00

0.00

DTT 09/08/06

30 0

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

DTT 09/08/06

30

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Accept



Setup Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

88 09/08/10



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

=> 09-08-10



HandFinish

Memo

0.00

Hand Finishing

(X30) 24

150

QC5- Inspect part completeness to step on W/O

0.00

=> 09/08/10



QC

Memo

0.00

Quality Control

(X30) 4

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Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

M112260

0.00

Mask inside of 0.8120" diameter hole START TIME:

1.45pm COVEN TEMPERATURE: 211pm FINISH

TIME: 330pm

=> 09-08-10

x 30

W

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

=> 330pm

minutes

(x 30)

4

180



Small Fab

Small Fab

Small Fab

0.00

0.00

Memo

1- Press D2611 bearing into lug as per Dwg D3041 12- Stake bearing into place as per Dwg D3041 **PLEASE SEE JASON BEFORE PRESSING BEARINGS FOR NEW TOOLING**

RE

08/08/11

(4)

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Page 4

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Req'd Qty: 30.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

=) S 09/08/11



QC

Memo

0.00

Quality Control



200

Identify as per dwg & Stock Location: 467

0.00



Packaging

Memo

0.00

Packaging

9/8/11 (4) 50

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09-08-11

MF 09-08-21

Picklist Print

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Work Order ID: 51159

Parent Item: D3041-1RevC-1

Parent Item Name: Clamp

Comments:

Start Date: 8/05/09

Required Date: 8/10/09

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2423RevB1

Manufactured No

180

f

760.9447

2.6305



Lug Extrusion

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

760.94468

43722

213.01468

44529

22.39

45800

525.54

D2611RevC

Manufactured No

100

Each

37.0000

30.0000



Bearing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

37

46841

8

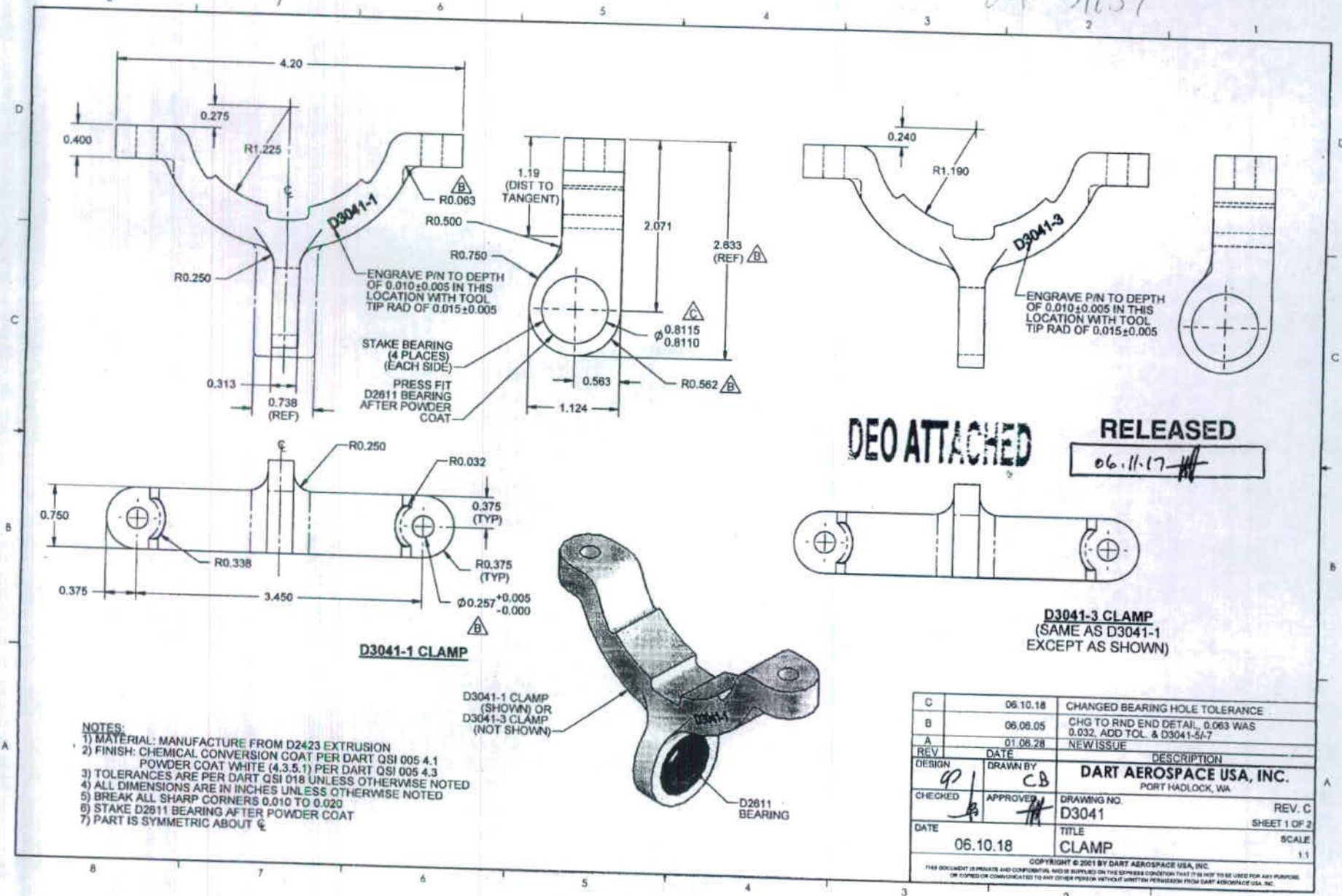
50521

29

3,125(F) DT 8/6/09

4 80 08/08/09

4051659



DEO ATTACHED

RELEASED

06.11.17

D3041-3 CLAMP
(SAME AS D3041-1
EXCEPT AS SHOWN)

D3041-1 CLAMP

D3041-1 CLAMP
(SHOWN) OR
D3041-3 CLAMP
(NOT SHOWN)

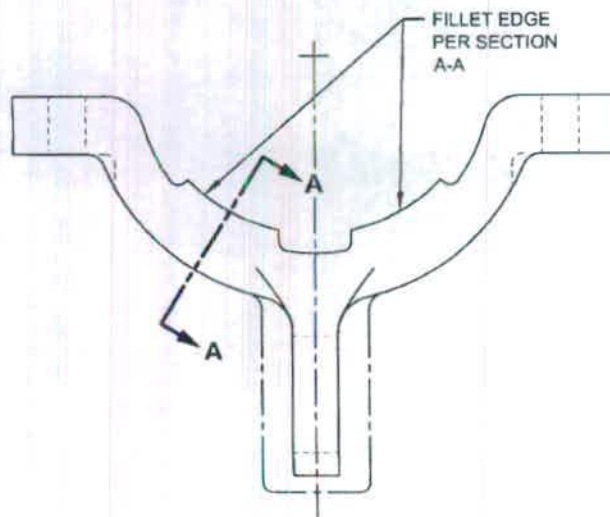
D2611
BEARING

- NOTES:
- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
 - 6) STAKE D2611 BEARING AFTER POWDER COAT
 - 7) PART IS SYMMETRIC ABOUT C

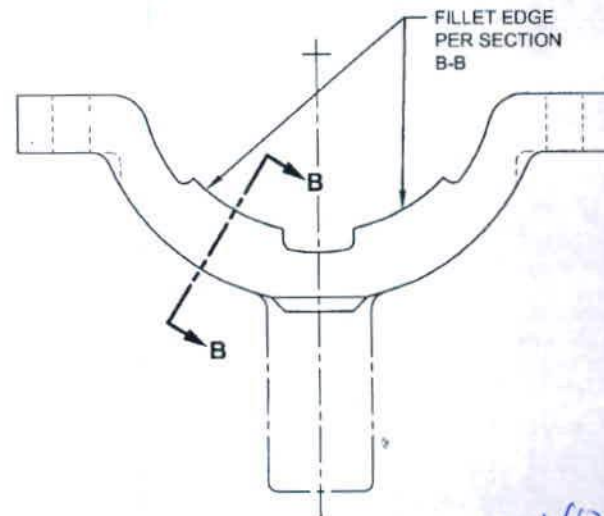
C	06.10.18	CHANGED BEARING HOLE TOLERANCE
B	06.08.05	CHG TO RND END DETAIL, 0.063 WAS 0.032, ADD TOL. & D3041-5A-7
A	01.06.28	NEW ISSUE
REV	DATE	DESCRIPTION
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	PORT HADLOCK, WA
DATE	06.10.18	DRAWING NO. D3041
		TITLE CLAMP
		REV. C
		SHEET 1 OF 2
		SCALE 1:1
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DRAWING NO. D3041	TITLE CLAMP	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3041-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED	DE APPR.		
DATE 09.03.04	DATE 09.03.12	DATE 09.03.12	DATE 09.03.13	DATE 09.03.13		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



D3041-1 CLAMP
D3041-3 CLAMP



D3041-5 CLAMP
D3041-7 CLAMP

W/O 51159



R0.060 MIN - R0.10 MAX
2PL

SECTION A-A
SCALE 2X
SECTION B-B
SCALE 2X

RELEASED
09/07/07

SEE PAR 122 FOR FURTHER DETAILS

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DART AEROSPACE LTD		Work Order: 51159
Description: CLAMP		Part Number: D341-1
Inspection Dwg: D341-1	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	±0.030	4.203	✓			
0.275	±0.010	0.275	✓			
0.400	±0.010	0.393	✓			
R1.225	±0.010	1.225	✓			
RO.250	±0.010	0.250	✓			
0.313	±0.010	0.310	✓			
RO.063	±0.010	0.063	✓			
RO.500	±0.010	0.500	✓			
RO.750	±0.010	0.750	✓			
1.124	±0.010	1.128	✓			
0.563	±0.010	0.567	✓			
RO.562	±0.010	0.562	✓			
Ø0.811	+0.005/-0.0000	0.811	✓			
2.633	±0.010	2.6345	✓			(REF)
2.071	±0.010	2.073	✓			
0.750	±0.010	0.753	✓			
0.375	±0.010	0.377	✓			(TYP)
3.450	±0.010	3.447	✓			
Ø0.257	+0.006/-0.001	0.258	✓			
RO.375	±0.010	0.375	✓			(TYP)
RO.032	±0.010	0.032	✓			
RO.250	±0.010	0.250	✓			

Measured by: DJP	Audited by: [Signature]	Prototype Approval:	N/A
Date: 09/08/06	Date: 09/08/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

